

Work Order ID 50170

July 9, 2009 3:12:02 PM

**PRELIMINARY ISSUE**

Page 1

Item ID: D3849-047
Revision ID: A-PRELIM
Item Name: WEARPLATE

Accept



Setup Start



Stop



Start Date: 07/09/2009 Start Qty: 1.00
Required Date: 07/09/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: _____

Prog Rev: _____

2-Deburr if necessary



0.00

110

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

See ATTACHED w/o

Work Order ID 50170

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Start Date: 07/09/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/09/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*See Attached
w/o*

130

0.00



Brake NC

Memo

0.00

Brake NC

Form as per Dwg

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

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Page 3

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Start Date: 07/09/2009 Start Qty: 1.00
Required Date: 07/09/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

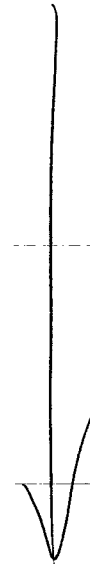
Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Large Fab	Memo 1-On D3901-1 bar, fill cut outs with hard coat welding rod as per Dwg 2059b Hardcoat rod Batch: _____ 2-Weld D3901-1 Bar to wearplate by positioning holes together as per Dwg 304ss Welding Rod Batch: _____	0.00 0.00							
160 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							
170 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

See Attached W/O



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Item ID: D3849-047

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Start Date: 07/09/2009 Start Qty: 1.00

Required Date: 07/09/2009 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

200

0.00



Small Fab

Memo

0.00

Small Fab

1-Bond D3848-7 gasket to inner surface of wearplate using a thin layer of 3m 1300/1300L Scotch grip adhesive
Batch: _____

See Attached W/O



Work Order ID 50170

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July 9, 2009 3:12:02 PM

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Accept



Setup Start



Stop



Start Date: 07/09/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/09/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
220 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
230 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

See ATTACHED w/o.

09/09/01
MF 09-07-09

RUSH

E

#50170

NOTE SHEET

DART
aerospaceProject # 00267Part# : **D3849-047**Description : Wearplate ass'y

If item not required write N/A in "responsible" column

Item	Action required	Responsible	Due Date	Done by / Date
1	16BA 0.063" m304S186A 0.050" thick Batch: <u>111924</u> Cut D3849-7 as per dwg	FB		9-6-36
2	M-NEO60-S.063 black neo 0.063" batch: <u>111853</u> Cut D3848-7 as per dwg	FB		
3	M304B0.500X2500 SS bar Batch: <u>110966</u> Cut D3901-1 as per dwg	FB		9-6-38
4	Bend wearplate as per dwg	FB	09/04/30	09/06/30
5	Weld as per dwg D3849	EL	D3849-04 30mins 01/07/2009	9-7-1
6	QC9/QC5 only 1	QC5 QC9 QC10 QC11 QC12 QC13 QC14 QC15 QC16 QC17 QC18 QC19 QC20 QC21 QC22 QC23 QC24 QC25 QC26 QC27 QC28 QC29 QC30 QC31 QC32 QC33 QC34 QC35 QC36 QC37 QC38 QC39 QC40 QC41 QC42 QC43 QC44 QC45 QC46 QC47 QC48 QC49 QC50 QC51 QC52 QC53 QC54 QC55 QC56 QC57 QC58 QC59 QC60 QC61 QC62 QC63 QC64 QC65 QC66 QC67 QC68 QC69 QC70 QC71 QC72 QC73 QC74 QC75 QC76 QC77 QC78 QC79 QC80 QC81 QC82 QC83 QC84 QC85 QC86 QC87 QC88 QC89 QC90 QC91 QC92 QC93 QC94 QC95 QC96 QC97 QC98 QC99 QC100	S.055 11.56 #1 326.9 F #2 JLF F #3 JLF F #4 JLF F	09-07-01
7	Powdercoat gray sandtex per QSI 005 AIR 3M 1300 M109091	AA		
8	QC3	BR		09-07-01
9	Bond gasket as per dwg M111428	SB	09	09/07/01
10	QC5	PH		09.07.01
11	Identify and Stock N/A PH 09.07.01			
12	QC21			
13				

DART AEROSPACE LTD		Work Order: 08267
Description: WEAR PLATE ASSY		Part Number: D3849-47
Inspection Dwg: D3849-047 Rev: PRE Lim		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .375	+ .006 - .001	.377	✗			
Ø .188	+ .005 - .001	.191	✗			
.125	± .030	.1254	✗			
.188	± .030	.188	✗			
.125	± .010	.126	✗			
2.433	± .010	2.433	✗			
6.801	± .010	6.799	✗			
7.88	± .030	7.873	✗			
2.45	± .030	2.45	✗			
18.000	± .010	18.000	✗			
36.000	± .010	36.000	✗			
51.313	± .010	51.313	✗			
5.89	± .030	5.89	✗			
54.26	± .030	54.25	✗			
34.500	± .010	34.500	✗			
4.00	± .030	4.001	✗			
7.00	± .030	7.002	✗			
4.38	± .030	4.381	✗			
.063	± .010	.058	✗			

Measured by: KB	Audited by: [Signature]	Prototype Approval:
Date: 9-6-30	Date: 9-07-01	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	00267
Description: WEAR PLATE ASS'y	Part Number:	D3848-7
Inspection Dwg: D3848-7 Rev: PRE Lim		Page 1 of 1

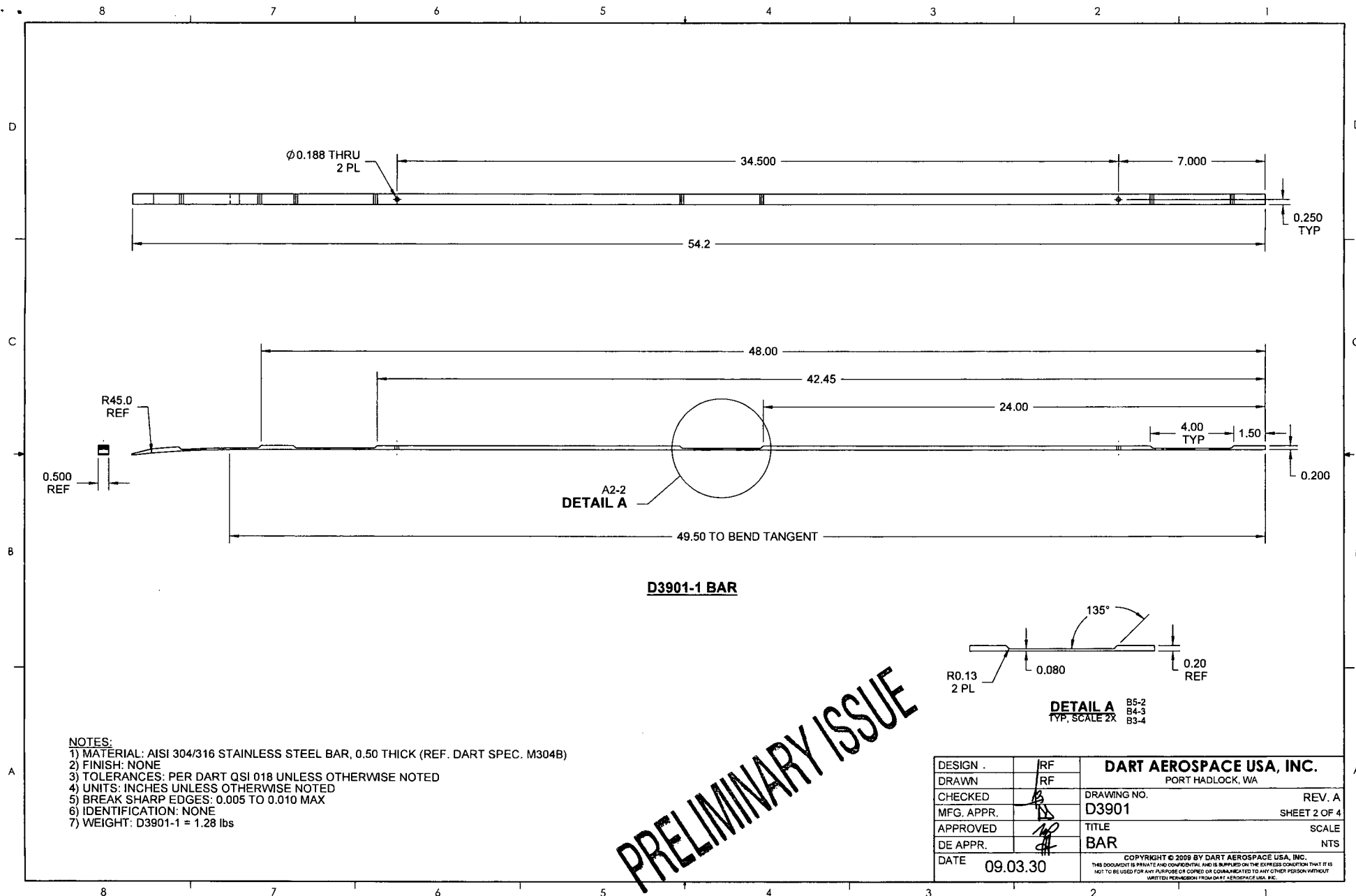
FIRST ARTICLE INSPECTION CHECKLIST

X

[illegible]

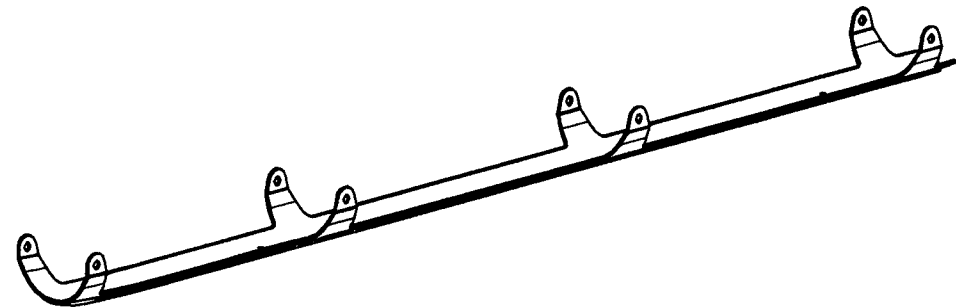
Measured by: 1B	Audited by: [Signature]	Prototype Approval:
Date: 9-7-1	Date: [Signature]	Date:

Rev	Date	Change	Revised by	Approved
A	...	New Issue	KJ/JLM	

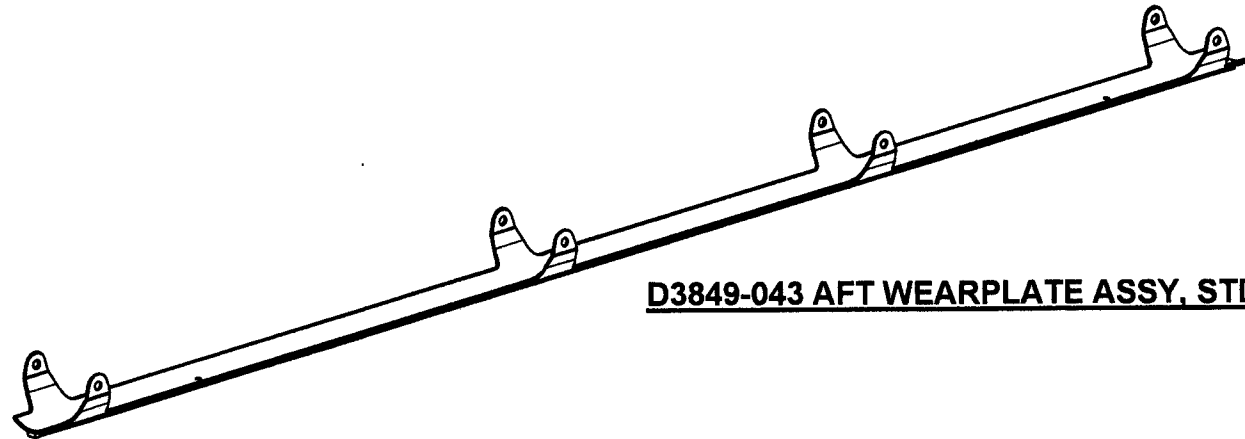


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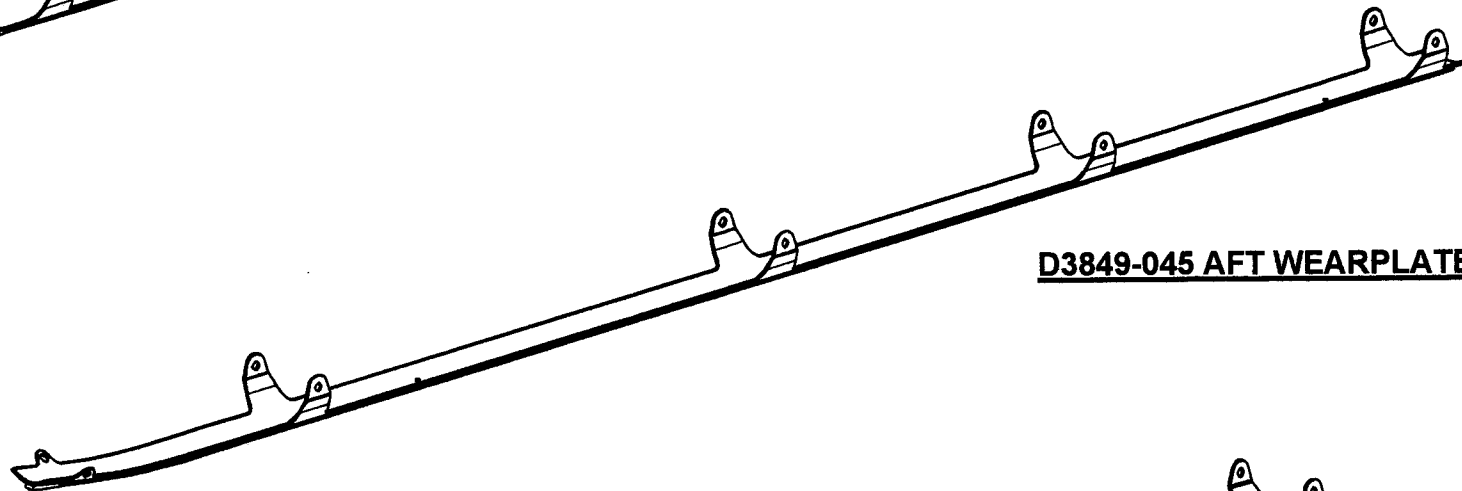
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3849-041	FWD WEARPLATE ASSY, STD GEAR
2		X			D3849-043	AFT WEARPLATE ASSY, STD GEAR
3			X		D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
4				X	D3849-047	FWD WEARPLATE ASSY, FLOAT GEAR
11	1				D3849-1	PLATE
12		1			D3849-3	PLATE
13			1		D3849-5	PLATE
14				1	D3849-7	PLATE
15	1				D3848-1	GASKET
16		1			D3848-3	GASKET
17			1		D3848-5	GASKET
18				1	D3848-7	GASKET
19	1			1	D3901-1	BAR
20		1			D3901-3	BAR
21			1		D3901-5	BAR
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE



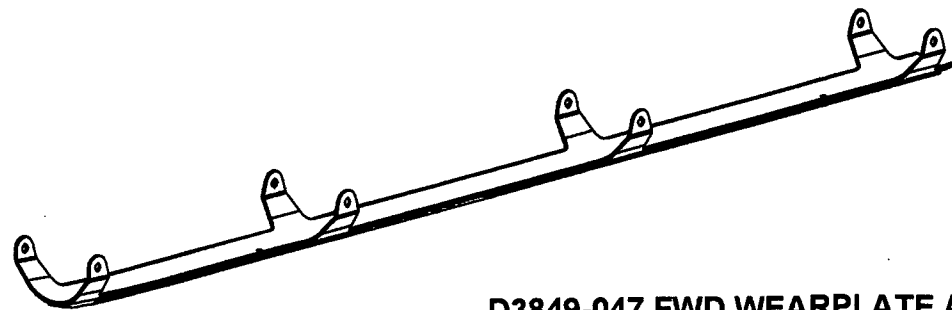
D3849-041 FWD WEARPLATE ASSY, STD GEAR



D3849-043 AFT WEARPLATE ASSY, STD GEAR



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR

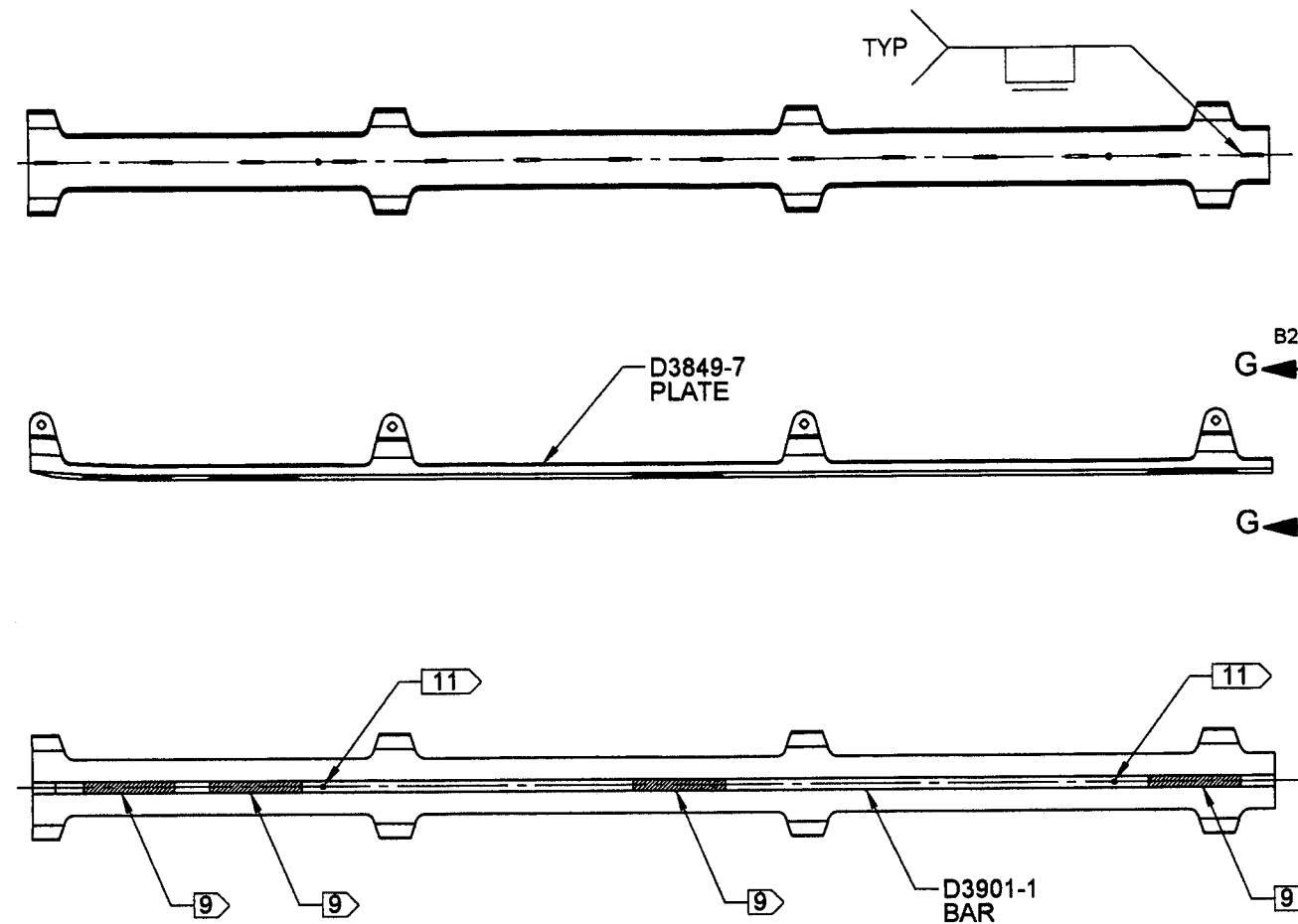


D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR

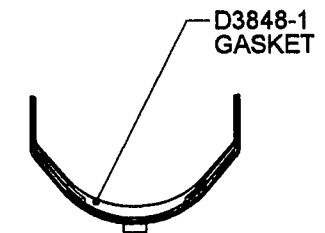
PRELIMINARY

B	REVISED FLAT PATTERN Ø0.375 WAS SLOT HOLE ON D3849-1F/-3F/-5F (ZN A4-5, B4-7, B4-8, C2-10, B2-10); ADD D3849-047 (ZN D4-1, A4-1 & B4-5) & D3849-7/-7F (ZN C4-9, A4-9); ADD DETAIL K (ZN C5-10); 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN A3-8); ADD 0.25 & 0.88 (ZN D4-10, D3-10); ADD 0.88 & 0.44 (ZN C3-10 & B3-10); ADD FLAG NOTE (ZN A8-2, C6-2, C3-2, A8-3, C6-3, C3-3, A8-4, C6-4, C2-4)	RF	09.06.26
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 1 OF 10
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	09.06.26	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR B



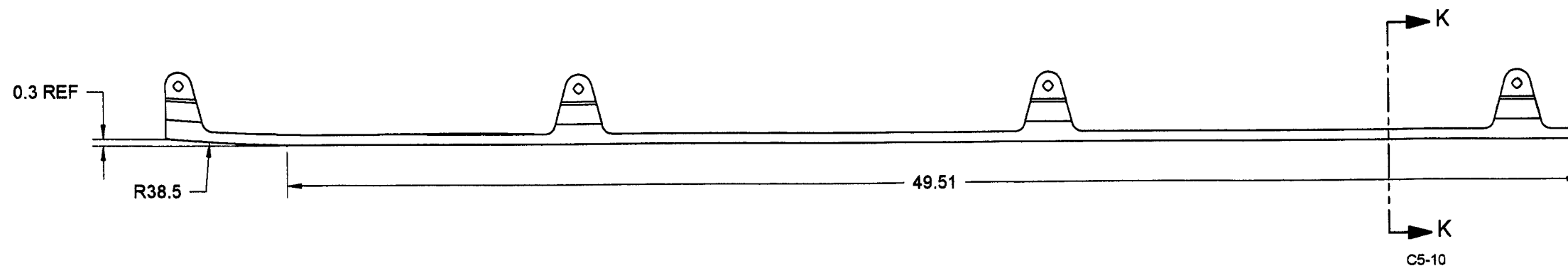
SECTION G-G C3-5
SCALE 2X

NOTES:

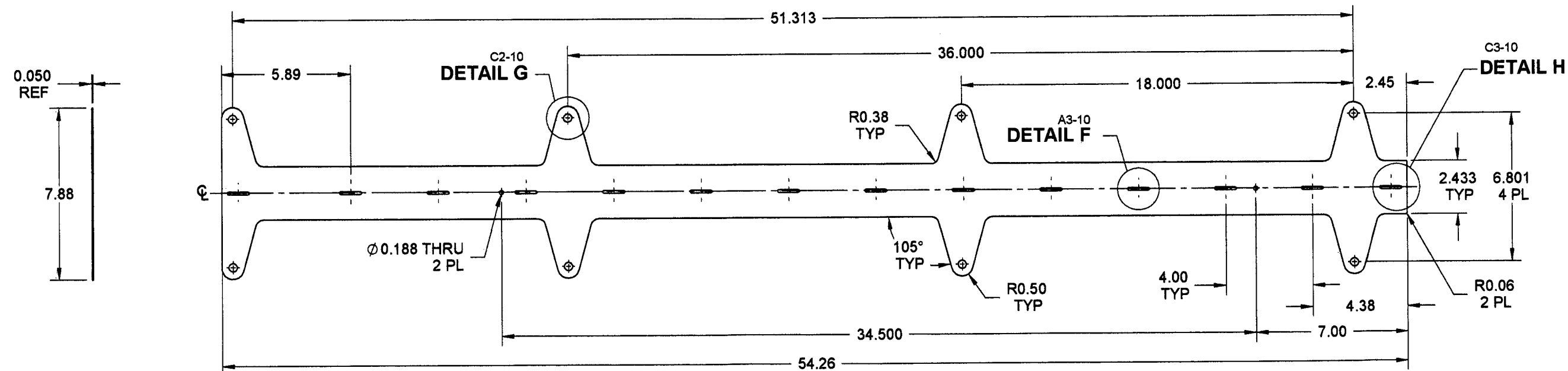
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-047" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-047 = 4.26 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-7 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D3849-7 PLATE TO D3901-1 BAR

PRELIMINARY

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 5 OF 10
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DE APPR.		WEARPLATE ASSY	NTS
DATE	09.06.26	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



D3849-7 PLATE 
(MAKE FROM D3849-7F)



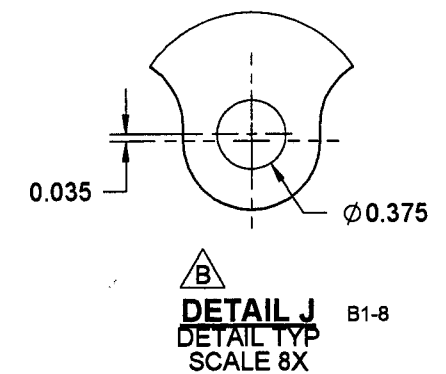
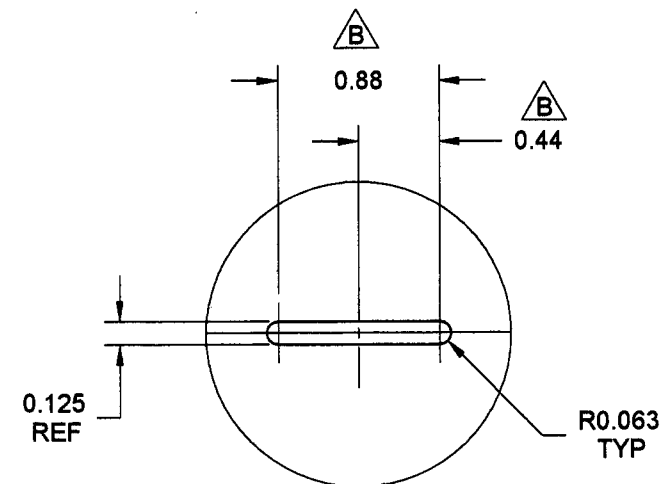
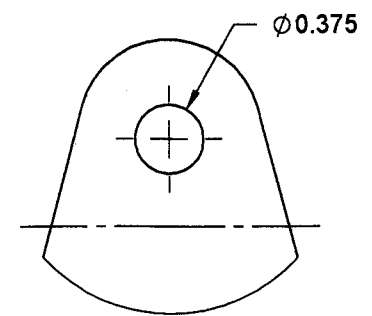
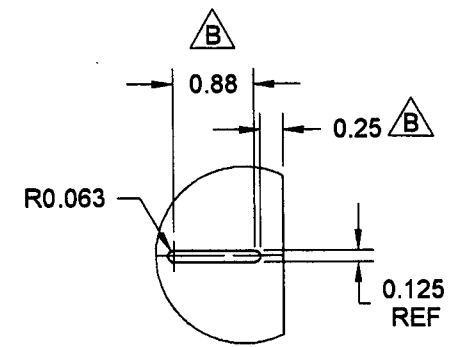
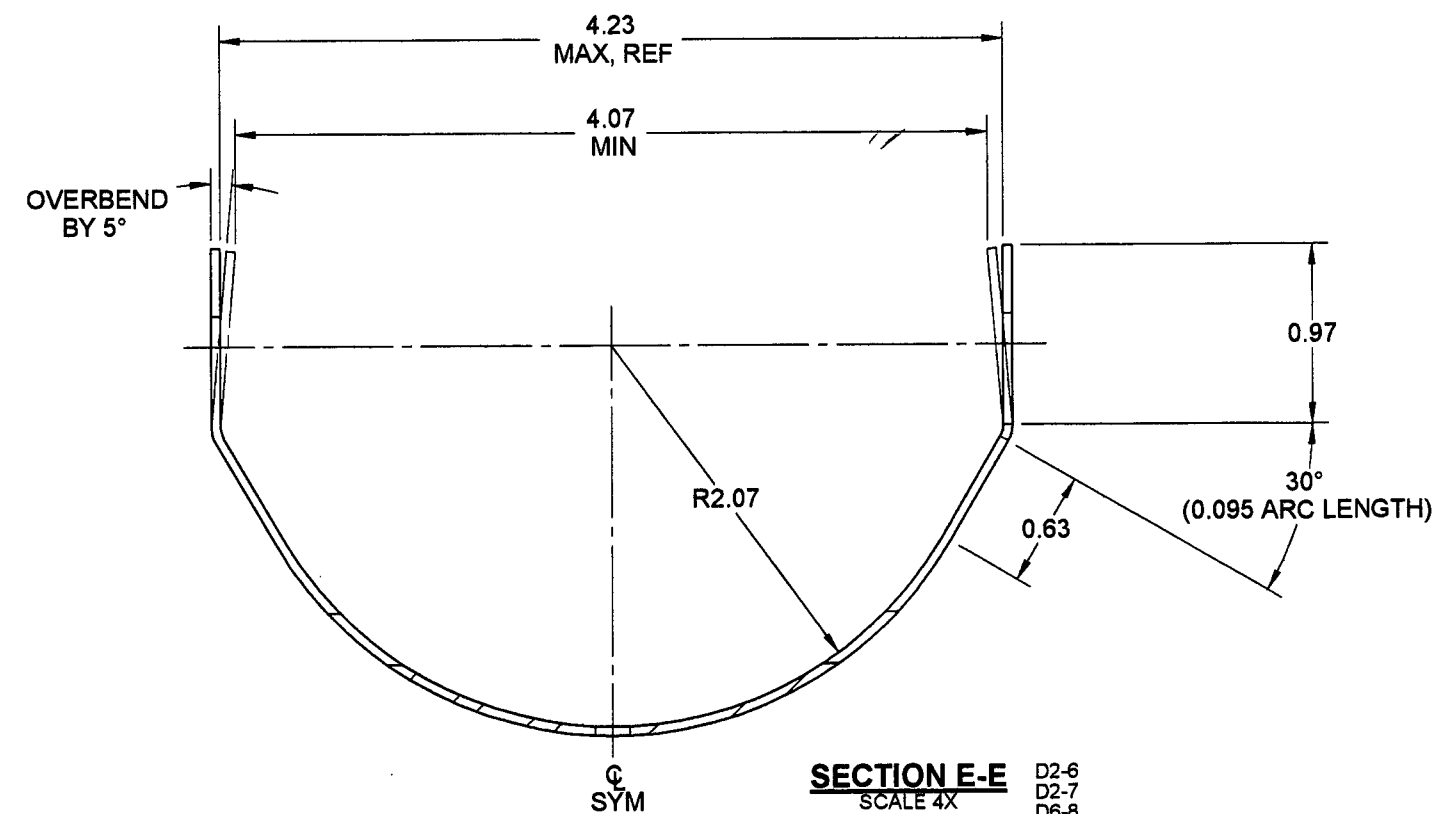
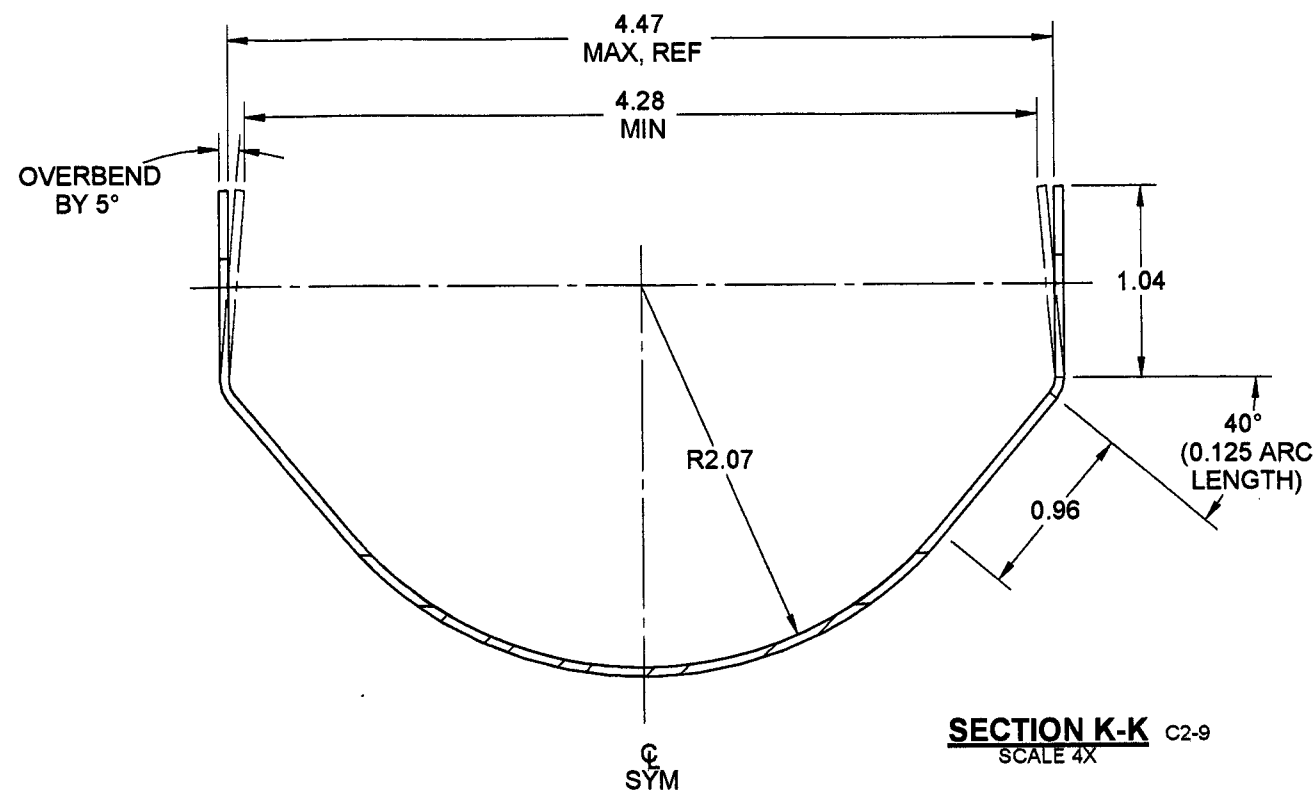
D3849-7F FLAT PATTERN 

PRELIMINARY

NOTES:

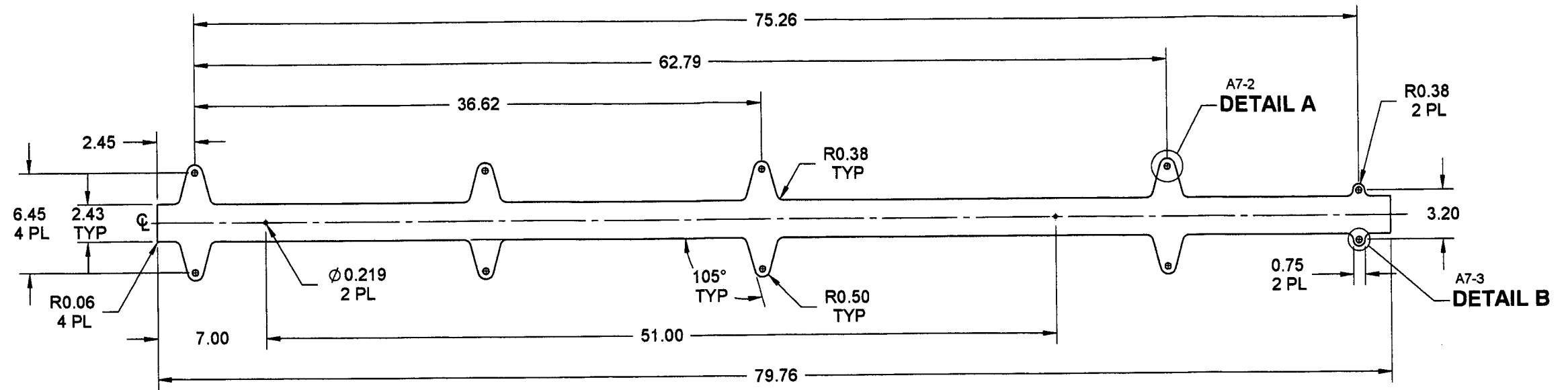
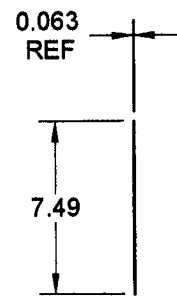
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.34 lbs

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 9 OF 10
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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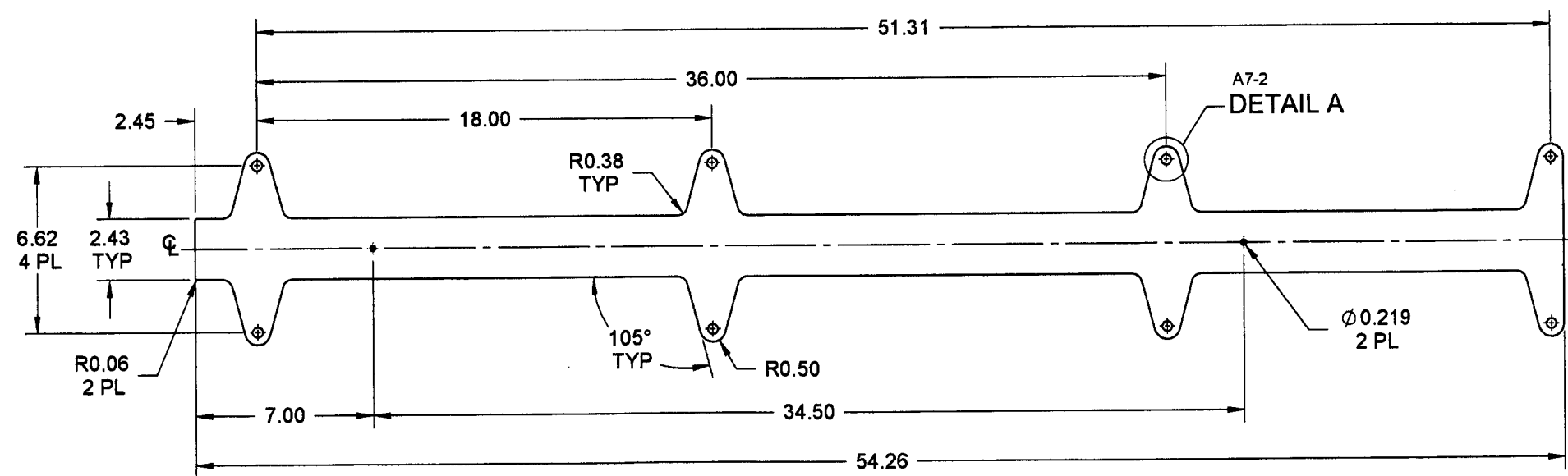
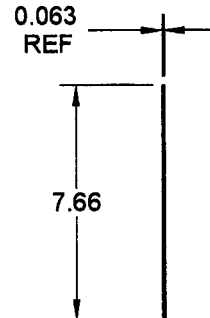


PRELIMINARY

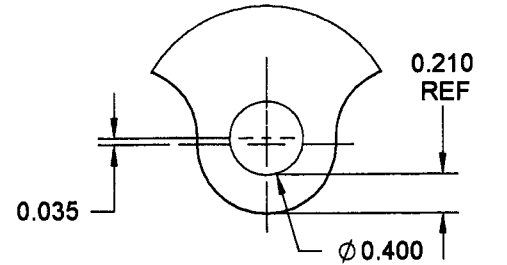
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 10 OF 10
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DE APPR.		WEARPLATE ASSY	NTS
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D3848-5 GASKET



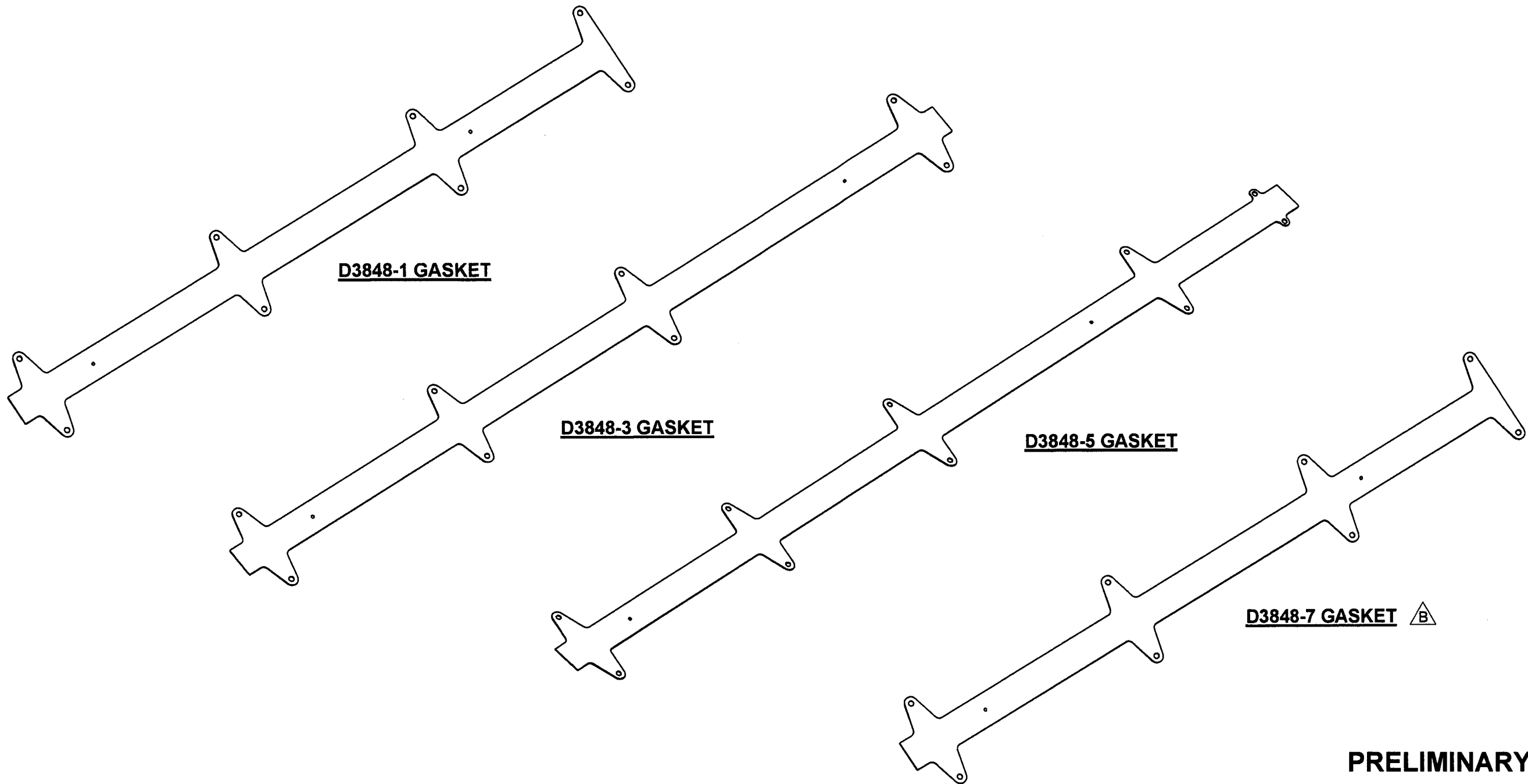
D3848-7 GASKET



DETAIL B: SLOT DETAIL TYP C1-3

PRELIMINARY

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3848	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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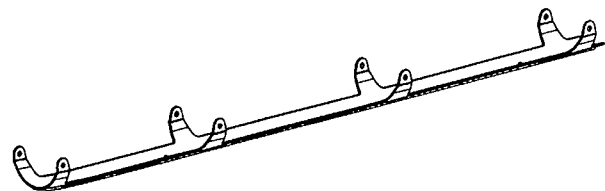
NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER
(REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3848-X" USING YELLOW PAINT MARKER
- 7) WEIGHT:
D3848-1 = 0.36 lbs
D3848-3 = 0.44 lbs
D3848-5 = 0.51 lbs
D3848-7 = 0.36 lbs

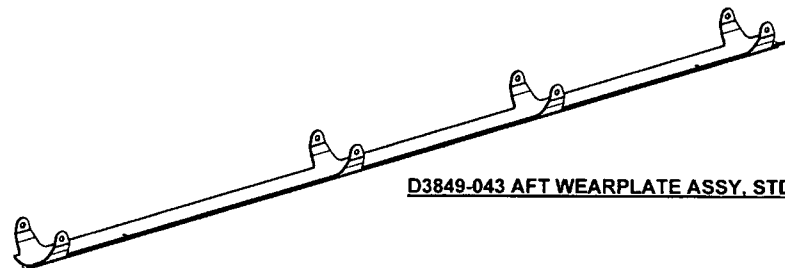
B	RE-DESIGN Ø0.400 WAS SLOT HOLE ON D3848-1/-3/-5 (ZN C4-2, A4-2, A8-2, C4-3, A7-3); ADD 3848-7 (ZN B2-1 & A4-3)	RF	09.06.26
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3848	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GASKET	NTS
DATE	09.06.26	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

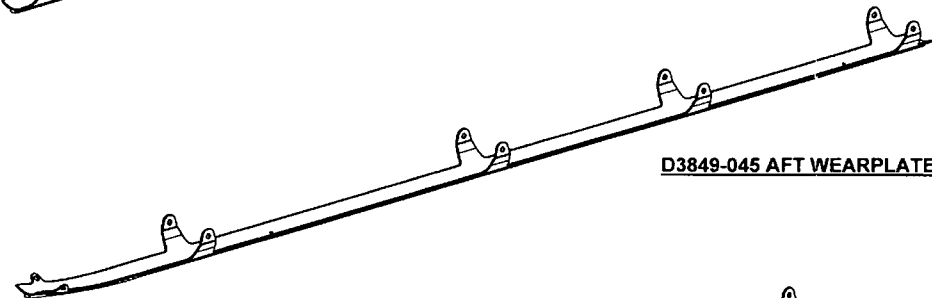
D
C
B
A



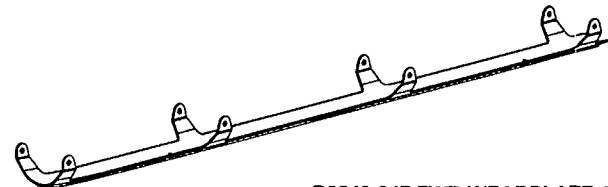
D3849-041 FWD WEARPLATE ASSY, STD GEAR



D3849-043 AFT WEARPLATE ASSY, STD GEAR



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR



D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3849-041	FWD WEARPLATE ASSY, STD GEAR
2		X			D3849-043	AFT WEARPLATE ASSY, STD GEAR
3			X		D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
4				X	D3849-047	FWD WEARPLATE ASSY, FLOAT GEAR
11	1				D3849-1	PLATE
12		1			D3849-3	PLATE
13			1		D3849-5	PLATE
14				1	D3849-7	PLATE
15	1				D3848-1	GASKET
16		1			D3848-3	GASKET
17			1		D3848-5	GASKET
18				1	D3848-7	GASKET
19	1			1	D3901-1	BAR
20		1			D3901-3	BAR
21			1		D3901-5	BAR
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

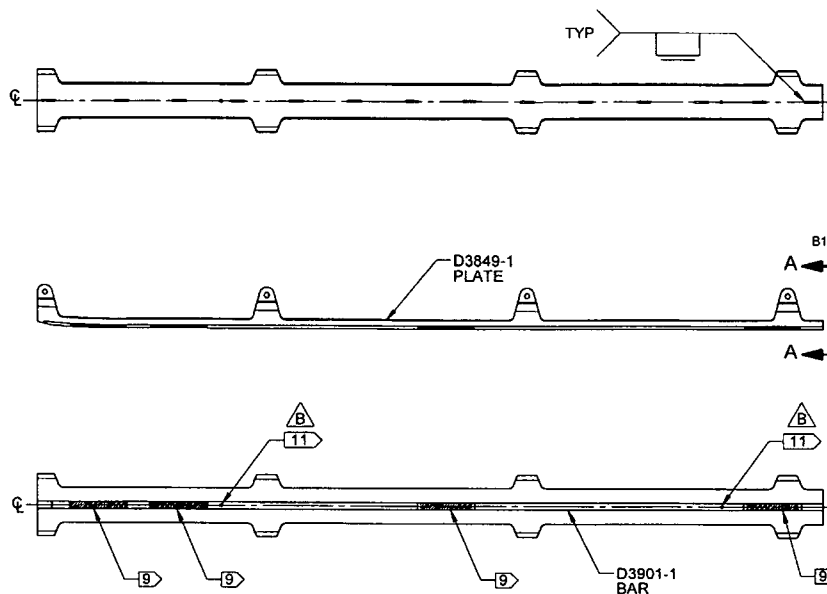
50170

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9/6/12

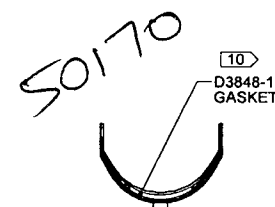
B	REVISED FLAT PATTERN Ø0.375 WAS SLOT HOLE ON D3849-1F/3F/5F (ZN A4-5, B4-7, B4-8, C2-10, B2-10); ADD D3849-047 (ZN D4-1, A4-1 & B4-5) & D3849-7/7F (ZN C4-9, A4-9); ADD SECTION K-K (ZN C5-10); 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN A3-10); ADD 0.25 & 0.88 (ZN D4-10, D3-10); ADD 0.88 & 0.44 (ZN C3-10 & B3-10); ADD FLAG NOTE (ZN A8-2, C6-2, C3-2, A8-3, C8-3, C3-3, A8-4, C8-4, C2-4); 66.87 WAS 67.38 (ZN S4-7)		RF	09.06.30
A	NEW ISSUE		RF	09.03.30
REV.	DESIGN		BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.		
DRAWN	RF	PORT HADLOCK, WA		
CHECKED	RF	DRAWING NO.	REV. B	
MFG. APPR.	RF	D3849	SHEET 1 OF 10	
APPROVED	RF	TITLE	SCALE	
DE APPR.	RF	WEARPLATE ASSY	NTS	
DATE	09.06.30			

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8 7 6 5 4 3 2 1



D3849-041 FWD WEARPLATE ASSY, STD/FLOAT GEAR



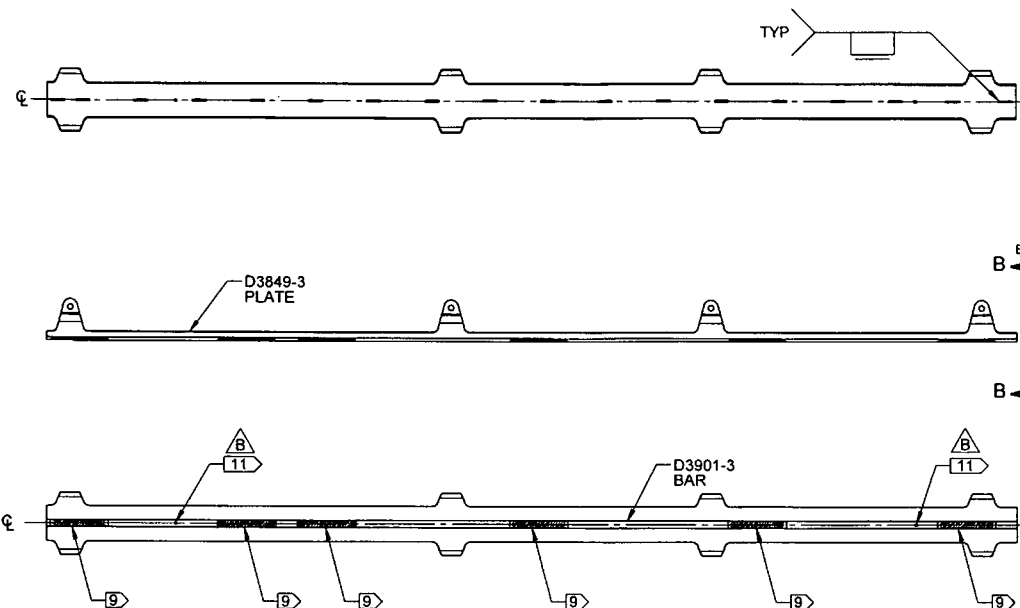
SECTION A-A C3-2
SCALE 2X

RELEASED
19/07/15

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-041" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-041 = 4.24 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-1 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D3849-1 PLATE TO D3901-1 BAR

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3849	REV. B
MFG. APPR.	RF	SHEET 2 OF 10	
APPROVED	RF	TITLE WEARPLATE ASSY	SCALE NTS
DE APPR.	RF	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.	
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D3849-043 AFT WEARPLATE ASSY, STD GEAR

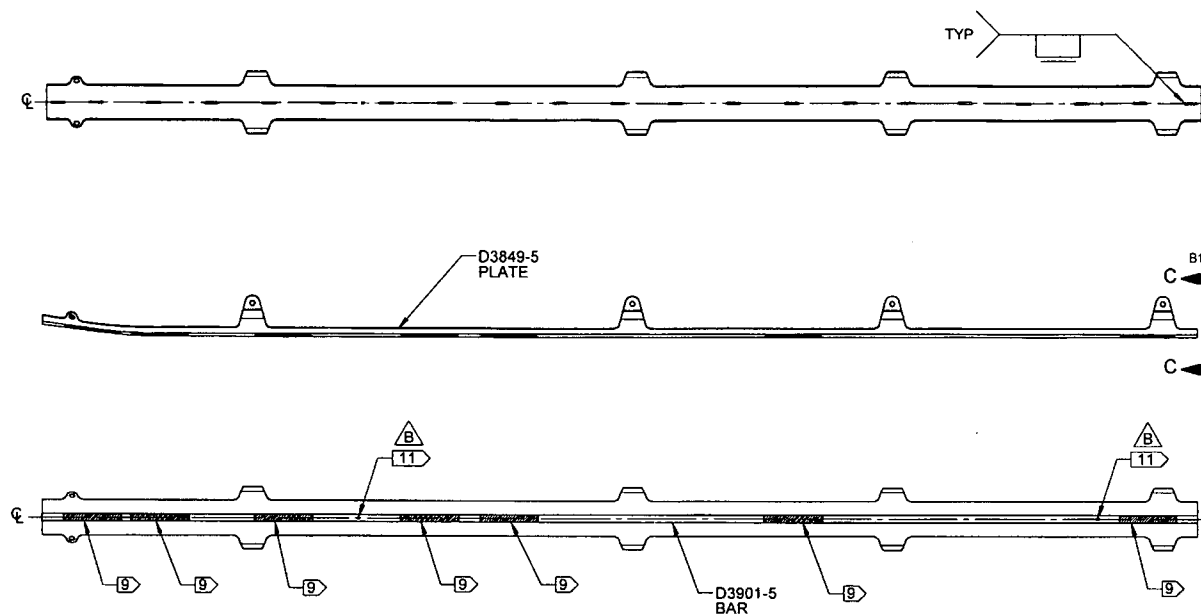
SECTION B-B C2-3
SCALE 2X

RELEASED
10/17/15

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3849-043 = 5.21 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-3 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL Ø0.188 HOLES FROM D3849-3 PLATE TO D3901-3 BAR

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3849	SHEET 3 OF 10
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
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D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR

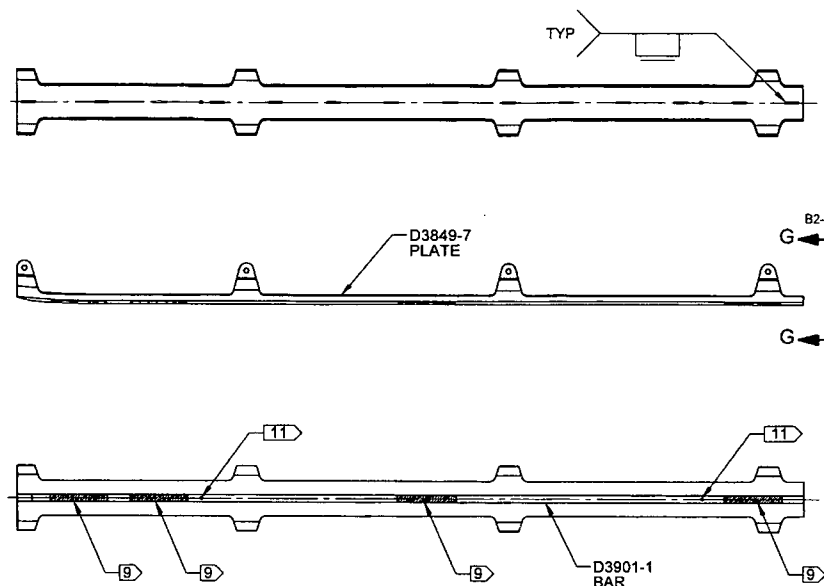
SECTION C-C C2-4
SCALE 2X

RELEASED
07/15/14

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-045" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-045 = 5.98 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3849-5 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-5 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\phi 0.188$ HOLES FROM D3849-5 PLATE TO D3901-5 BAR

DESIGN	RF	DART AEROSPACE USA, INC.	
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MFG. APPR.	RF	D3849	SHEET 4 OF 10
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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D3849-047 FWD WEARPLATE ASSY. FLOAT GEAR






SECTION G-G C3-5
SCALE 2X

50170

RELEASED
10/26/10

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-047" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-047 = 4.26 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-7 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D3849-7 PLATE TO D3901-1 BAR

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 5 OF 10
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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0.3 REF

R38.5

49.51

A6-10

D3849-1 PLATE
(MAKE FROM D3849-1F)

0.050
REF

7.72

51.313

36.000

DETAIL G

R0.38
TYP

DETAIL F

A3-10

18.000

C3-10
DETAIL H

2.45

2.433
TYP6.642
4 PLR0.06
2 PLØ0.188 THRU
2 PL105°
TYPR0.50
TYP4.00
TYP

4.38

54.26 REF

D3849-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.33 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3849	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE WEARPLATE ASSY	SHEET 6 OF 10
APPROVED	<i>[Signature]</i>	SCALE	NTS
DE APPR.	<i>[Signature]</i>	DATE 09.06.30	

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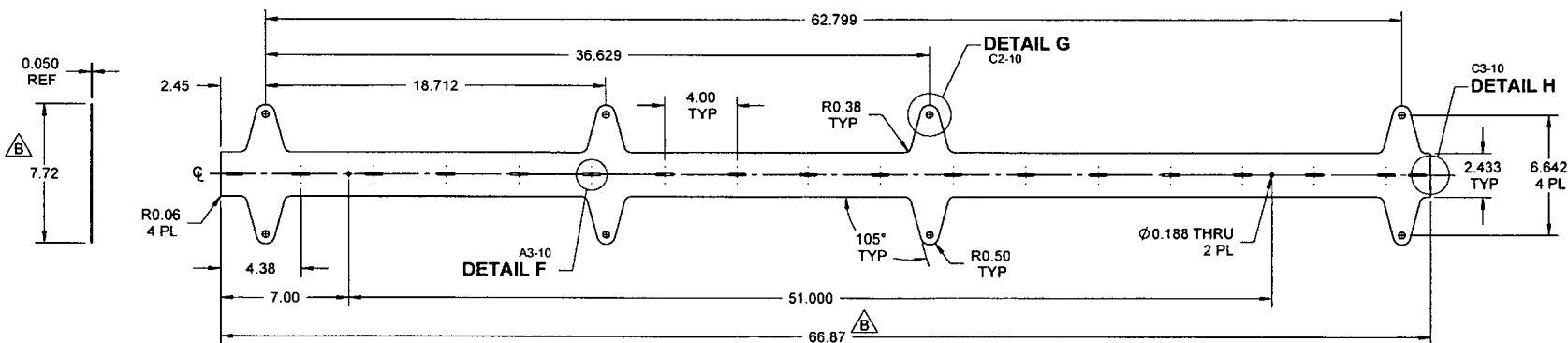
50170
RELEASED
09/17/2010

8 7 6 5 4 3 2 1



D3849-3 PLATE
(MAKE FROM D3849-3F)

E
E
A6-10



D3849-3F FLAT PATTERN

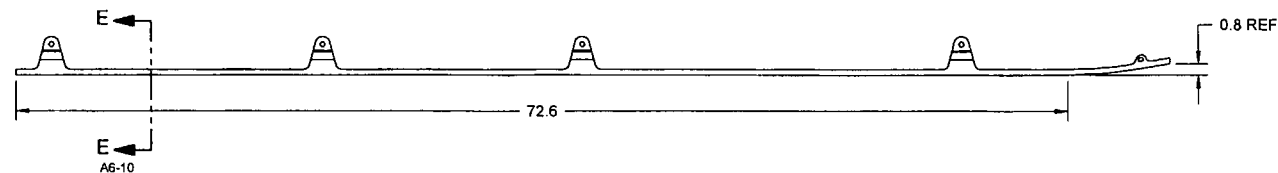
50170
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12/16/15

NOTES:

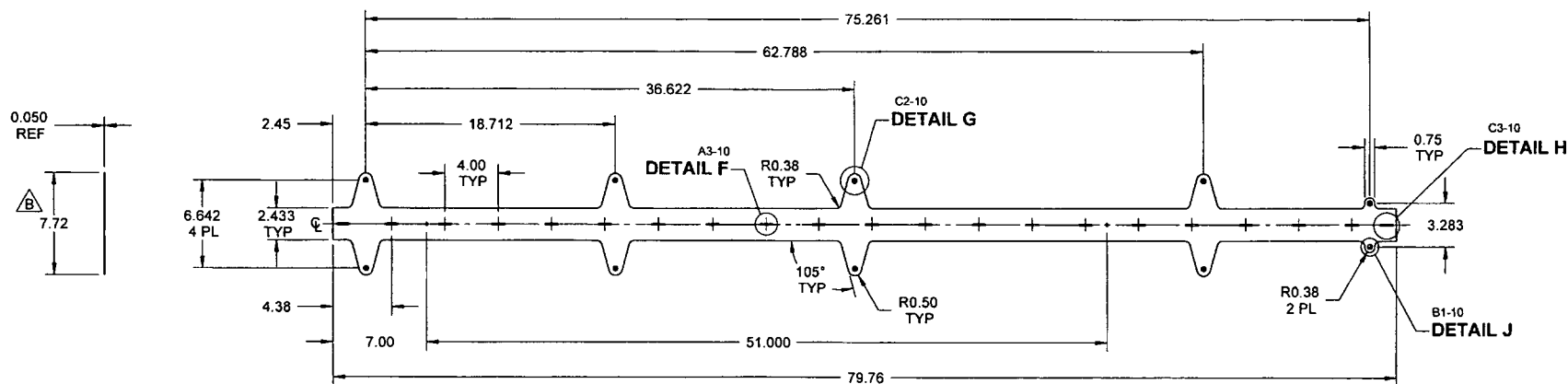
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.82 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 7 OF 10
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1



D3849-5 PLATE
(MAKE FROM D3849-5F)



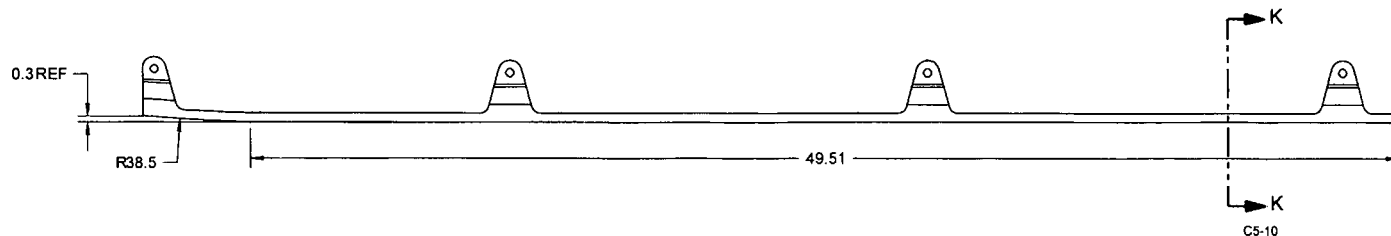
D3849-5F FLAT PATTERN

NOTES:

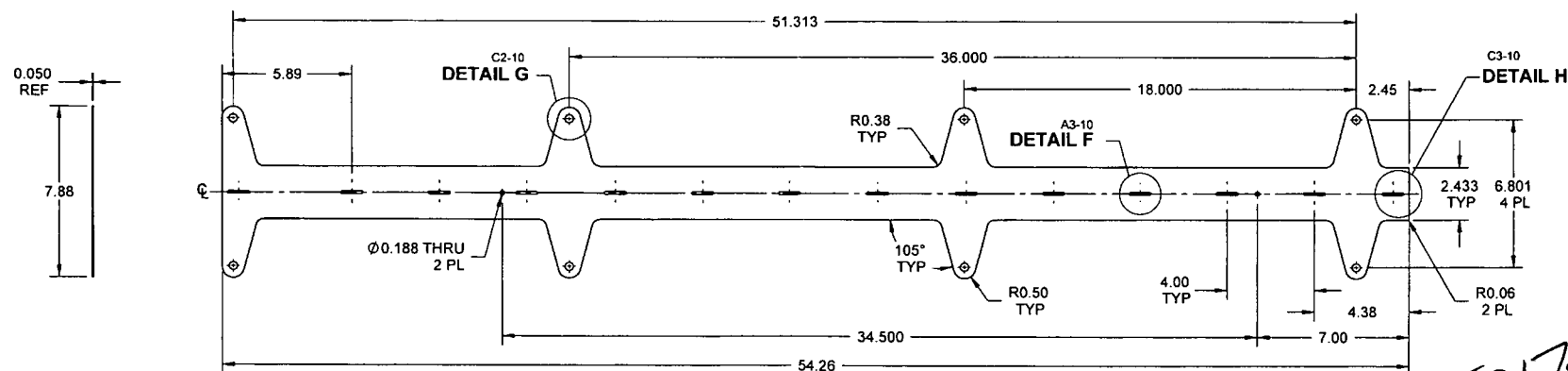
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.30 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 8 OF 10
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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9/6/54



D3849-7 PLATE $\triangle B$
(MAKE FROM D3849-7F)



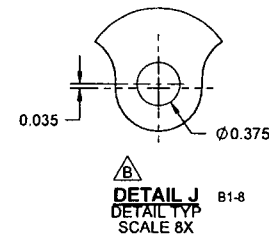
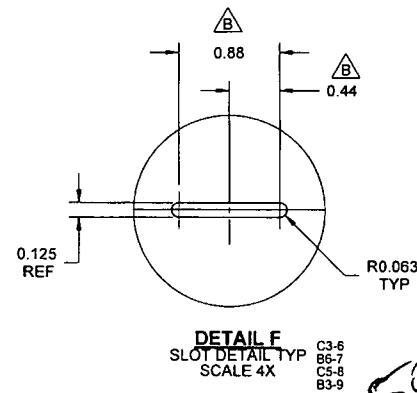
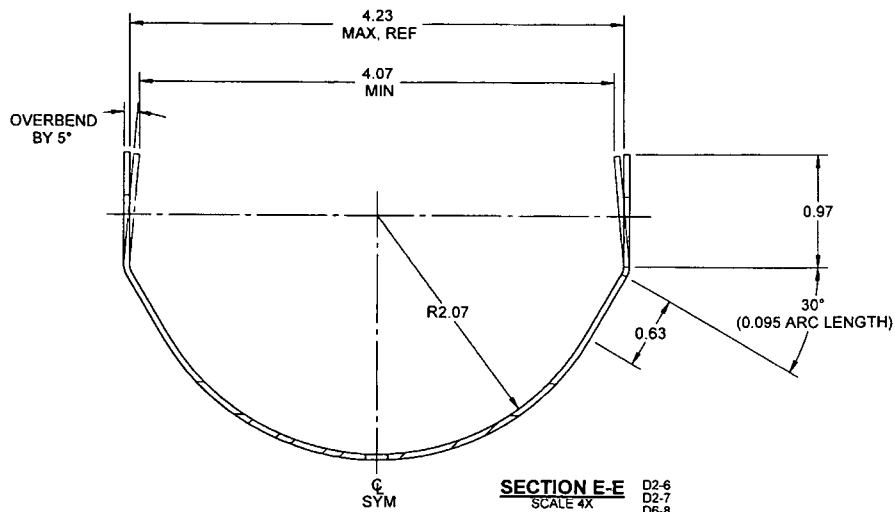
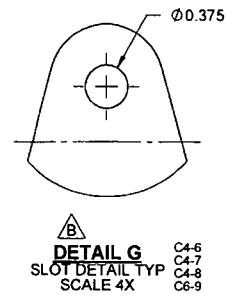
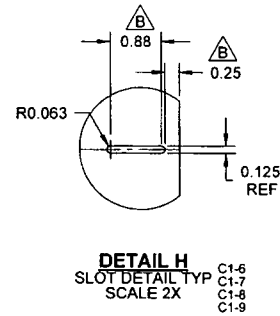
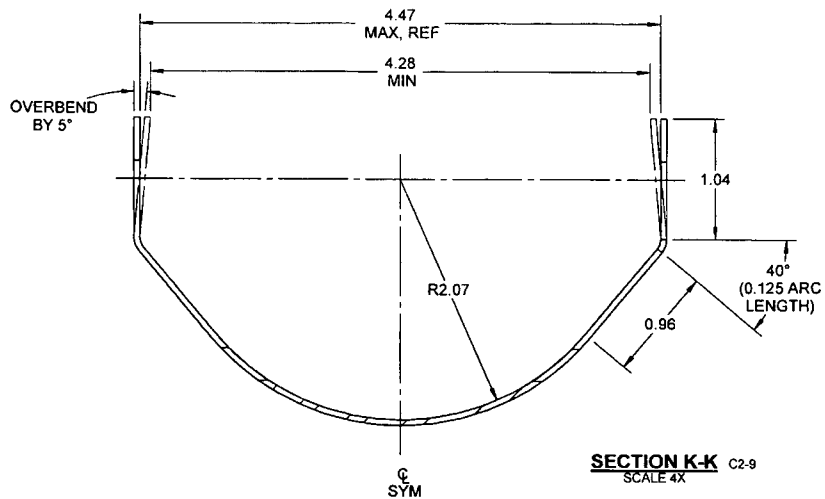
D3849-7F FLAT PATTERN $\triangle B$

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09/07/15

NOTES:

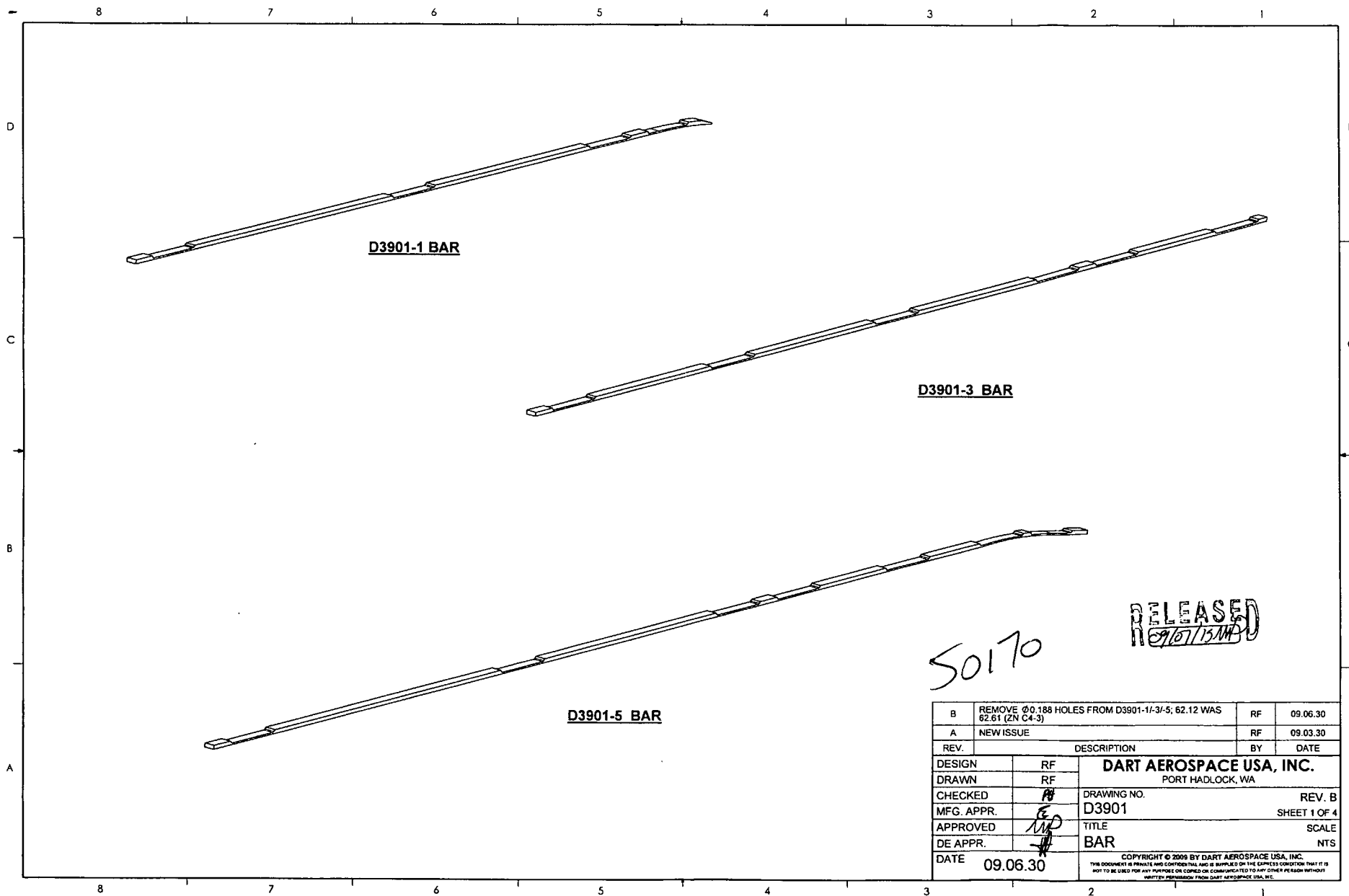
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.34 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO. D3849	REV. B
MFG. APPR.	RF	SHEET 9 OF 10	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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MFG. APPR.	RF	TITLE	SHEET 10 OF 10
APPROVED	RF	WEARPLATE ASSY	SCALE
DE APPR.	RF	DATE 09.06.30	NTS
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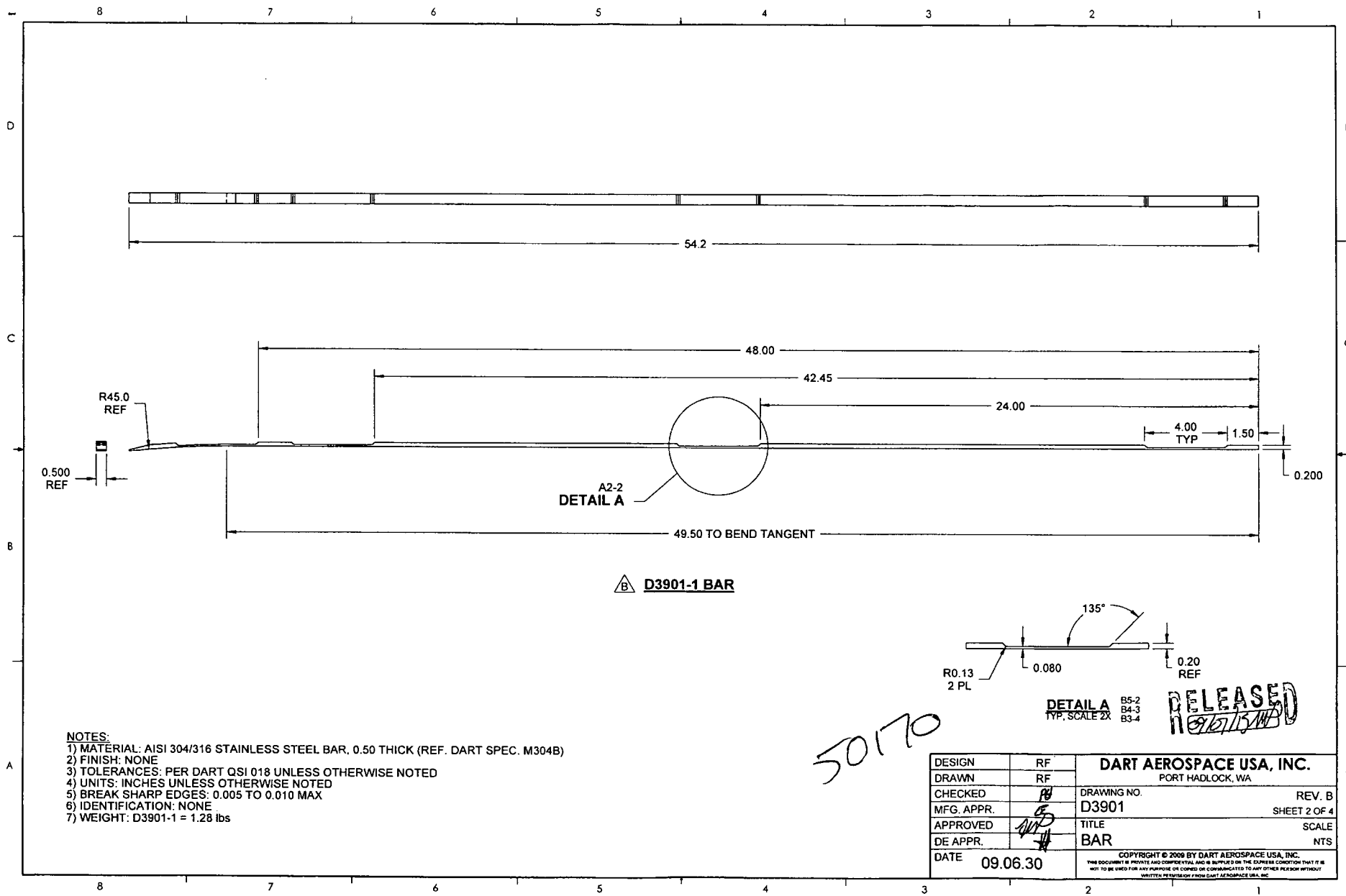
50170
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10/6/15



50170

RELEASED
29/07/13 MPD

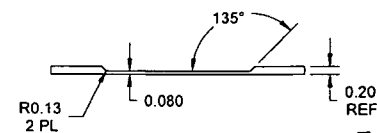
B	REMOVE Ø0.188 HOLES FROM D3901-1A-3F-5; 62.12 WAS 62.61 (ZN C4-3)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3901	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BAR	NTS
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△ D3901-1 BAR

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.50 THICK (REF. DART SPEC. M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3901-1 = 1.28 lbs



DETAIL A
TYP. SCALE 2X

B5-2
B4-3
B3-4

RELEASED
9/12/15

50170

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3901	SHEET 2 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BAR	NTS
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8 7 6 5 4 3 2 1

D

D

C

C

B

B

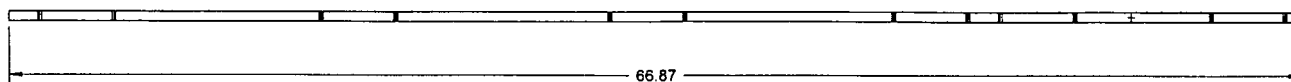
A

A

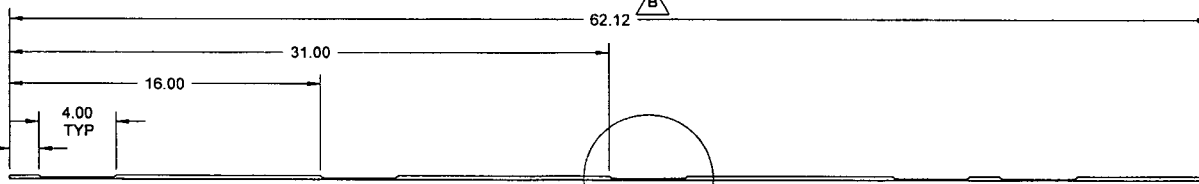
0.50
REF



1.50



66.87



62.12

31.00

16.00

4.00
TYP

0.20

DETAIL A
A2-2

D3901-3 BAR

NOTES:

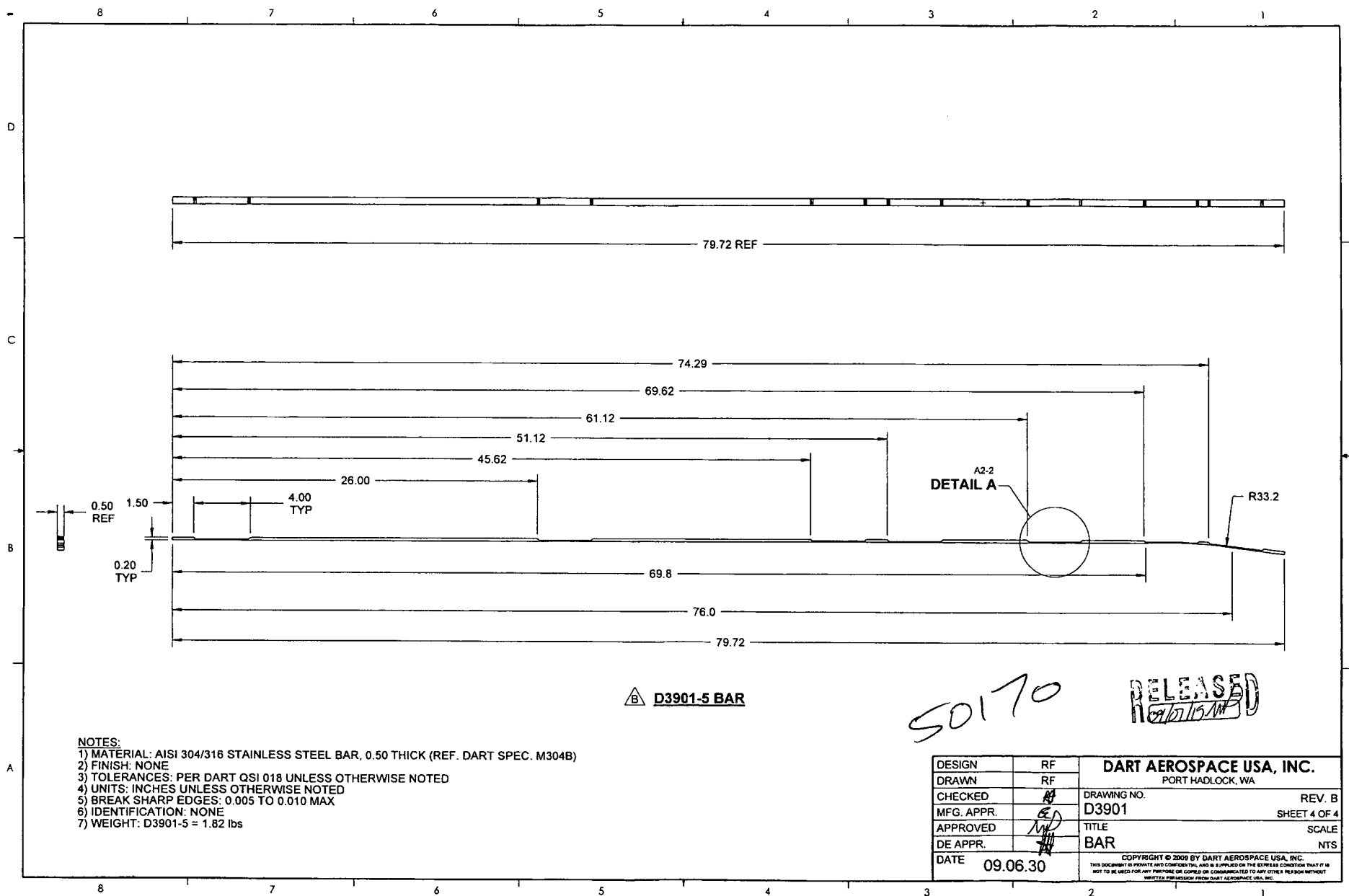
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.50 THICK (REF. DART SPEC. M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3901-3 = 1.53 lbs

50170

RELEASED
11/15/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3901	SHEET 3 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BAR	NTS
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8 7 6 5 4 3 2 1



D3901-5 BAR

50170

RELEASED
8/17/13

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.50 THICK (REF. DART SPEC. M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3901-5 = 1.82 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3901	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BAR	NTS
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